

Date: Thursday, 5/31/2007 7:23:26 AM
 User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 32719 EFFECTIVE 07.06.27 AUTH ll
 Estimate Number : 12576 RELEASED _____ DATE _____
 P.O. Number : NIA Part Number : D3562041
 This Issue : 5/31/2007 S.O. No. : NIA Drawing Number : D3562 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 32718 Material : NIA
 Written By : _____ Due Date : 6/30/2007 Qty: 6 Um: Each
 Checked & Approved By : 07.05.31
 Comment : Est Rev:A New Issue 06-11-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 531984

Check Material for any Dents or Defects

a.m 07.06.27 6

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D2734 End Cap 330883

DE 07.07.03 6

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

a.m 07.06.27 6

2-Deburr and bevel ends for welding

a.m 07.06.27 6

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

07.07.10 6

4-Grind end cap welds flush as per Dwg D3562

a.m 07.07.10 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:26 AM
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Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 07/07/03 (X6)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. USING DT 8956

AM 07.06.27

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 07/07/03 (X6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 07.06.27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE 07.06.28

9.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

B 32643

PE 07.06.28

10.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

ARM WELDMENT

Batch: B 32646

PE 07.06.28

11.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Blind Rivet

batch: M8953

AM 07.07.03

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

FF 07-07-11

A/R Magnabond 6398

Batch: M104627

a.m 07.07.03

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/03

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

2-Grind end cap welds flush as per Dwg D3562

07.07.05

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP-07/07/11

All 6 were tested on the Helicopter

17.0

POWDER COATING

TOUCH-UP ALUMINUM

POWDER COATING

07-07-16



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-07-17

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M104733

FR 07/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/23

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

4 Apr 18

7 Apr 18

7 Apr 17

→ 19.1) - Pick 2x D2808 bushings, B 32752 MF 0707-18

19.2) Press Kit as per drawing

19.3) QC 5 - on 07/07/18 (x6)

QC21 07.07.18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

RELEASED

01.01.2008

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

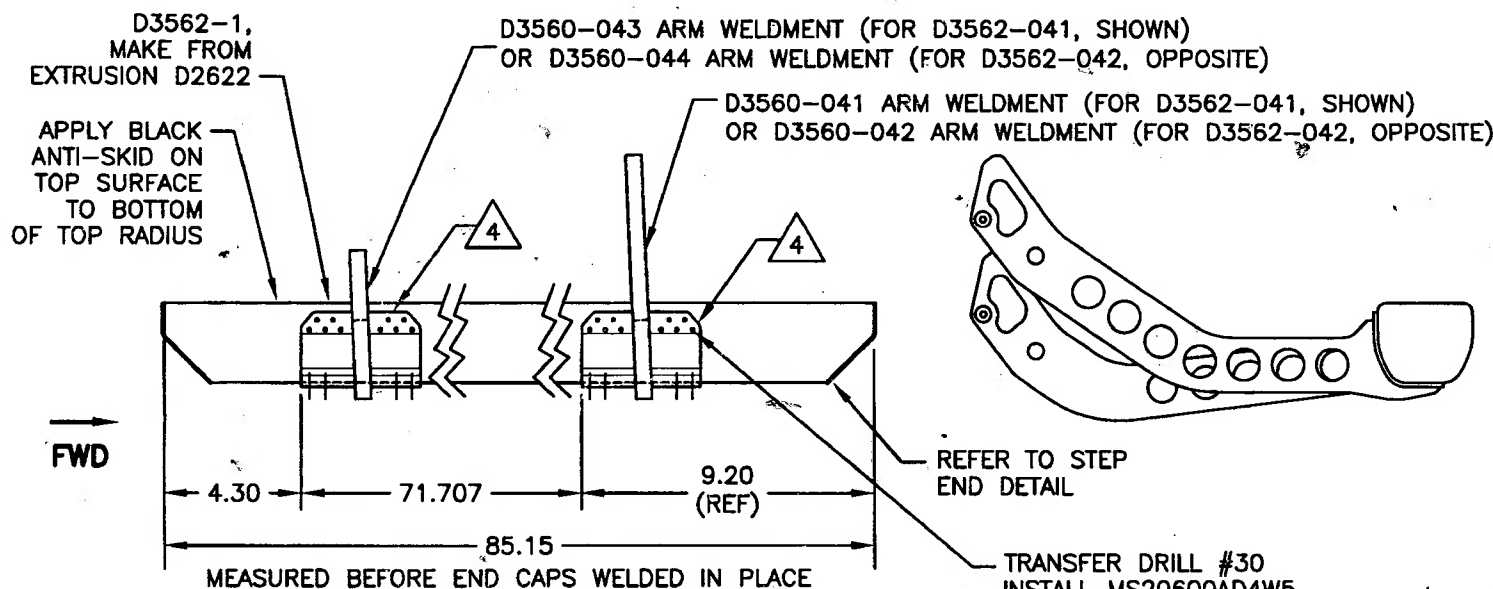
1.00

45.0°

D2734, END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32719



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:

AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:

- i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
 - 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
90	90	DRAWING NO.	REV. B
CHECKED	APPROVED	D3562	SHEET 1 OF 1
DATE		TITLE	SCALE
07.01.15		STEP ASSEMBLY	NTS
A	06.09.26	NEW ISSUE	
B	07.01.15	ARMS NOW RIVETED TO STEP	